

Date: Friday, 7/14/2006 12:01:23 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	: LUG
Job Number	27923			
Estimate Number	10008			
P.O. Number	N/A		Part Number	: D2591
This Issue	7/14/2006	S.O. No. : N/A	Drawing Number	: D2591 REV D
Prsht Rev:	NC		Project Number	: N/A
First Issue	N/A	Type : MACHINED PARTS	Drawing Revision	: D
Previous Run	26449		Material	: N/A
Written By			Due Date	: 10/8/2006
Checked & Approved By		RJ 06.07.14	Qty:	40
Comment	Est Rev: Removed from 9 Digit	05-10-25	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010B0750X02500	ASTM A21 Steel .75"x2.5"
		Comment: Qty.: 0.2340 f(s)/Unit Total : 9.3600 f(s) ASTM A36 Steel bar 2.50" x 0.75" thick(M1010-B0.750X02.500) Batch: 101926
2.0	BAND SAW	BAND SAW
		Comment: BAND SAW Cut blanks: 2.700" long
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA 039 and Dwg D2591
		2-Deburr if required
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
5.0	QC8	SECOND CHECK
		Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: 

Date: 06/08/28

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Friday, 7/14/2006 12:01:23 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 27923

Part Number: D2591

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	PACKAGING 1	PACKAGING RESOURCE #1
	<p>Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>GT51</u></p> <p><i>AB 06/08/28</i> </p>	
7.0	DC	DOCUMENT CONTROL
	<p>Comment: DOCUMENT CONTROL Inspection Level 21</p> <p><i>49</i> </p>	

Job Completion



CL 06/08/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

John C. Weller

DART AEROSPACE LTD	Work Order:	27923
Description: GHW Lug	Part Number:	D2591
Inspection Dwg: D2591	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

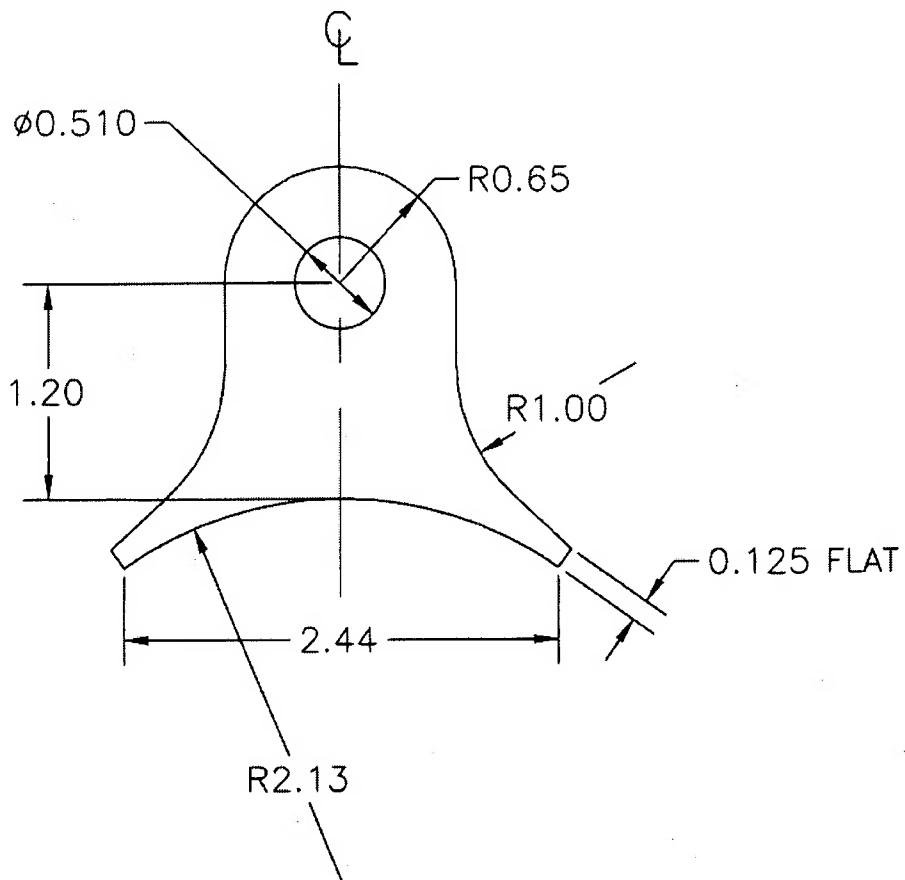
X First Article Prototype

Measured by: SD	Audited by: J.G	Prototype Approval: N/A
Date: 06.08.26	Date: 06/08/26	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue P/O D205-641-011 & DSI 9161-011	KJ/JLM	<i>[Signature]</i>

DART

DESIGN <i>DMY</i>	DRAWN BY <i>DMY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>BW</i>	DRAWING NO. D2591	REV. D SHEET 1 OF 1
DATE 98.01.21		TITLE GHW LUG	SCALE 1:1
A	96.09.16	NEW ISSUE	
B	97.06.17	RE-DESIGN TO FLAT BOTTOM	
C	97.12.12	RE-DESIGN TO RADIUS BOTTOM	
D	98.01.21	0.125 FLAT WAS 0.067 FLAT	

RELEASED
98.01.21 DS

BREAK ALL SHARP CORNERS ~~0.010 TO 0.020~~
 MATERIAL: ASTM A36 STEEL 0.50 THICK
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 PART IS SYMMETRIC ABOUT CENTER-LINE
 ALL DIMENSIONS ARE IN INCHES

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 27923